

Date: Tuesday, 9/11/2007 10:53:47 AM
 User: Chantal Lavoie

Process Sheet

Customer :	Drawing Name :	BRACKET	
Job Number : 34537			
Estimate Number : 12966			
P.O. Number : <i>N/A</i>	Part Number :	D3637041	
This Issue : 9/11/2007	Drawing Number :	D3637 <i>UNDER REVIEW</i>	
Prsht Rev. : NC	Project Number :	N/A	
First Issue : <i>N/A</i>	Drawing Revision :	<i>REV A</i>	
Previous Run : 33726	Material :	<i>A</i>	
Written By : <i>W</i>	Due Date :	9/18/2007	Qty: 24 Um: Each
Checked & Approved By : <i>W</i>			
Comment : Est Rev:A New Issue 07-07-20 JLM	Verified By: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S14GA	304SS .080
-----	-----------	------------



Comment: Qty.: 0.0945 sf(s)/Unit Total: 2.2680 sf(s)

304SS .080

Batch: *M105112 B07-09-11*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3637

Dwg Rev: *PREL*Prog Rev: *PREL*

2-Deburr if necessary

*B07-09-11**(25)**07/09/12 (25)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B07-09-12

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07/09/13

5.0	BRAKE NC	NC BRAKE
-----	----------	----------




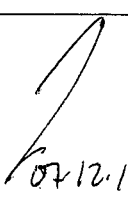
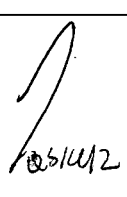
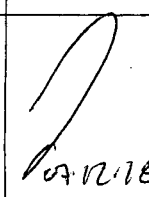
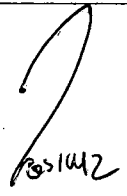


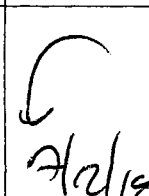
Comment: NC BRAKE

Form as per Dwg D3637

*B07/12/18**5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector















Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/12/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/18	5+8	6 piece were scrap wrong offset die + fix jig for hole location	 05/11/12	Scrap + destroy No replace	SN 07/12/18	 07/12/18	 05/11/12	 07/12/18
07/12/18	5D	Four (4) parts SCRAP Do not conform to the Draw.	 05/11/12	SCRAP NO Replace	CP 07/12/19	 07/12/19	 05/11/12	 07/12/18

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:53:47 AM
User: Chantal Lavoie

Process Sheet

Customer:		Drawing Name: BRACKET	
Job Number: 34537		Part Number: D3637041	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
6.0	MS21059L4	Nutplate	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s) Nutplate BATCH: <u>m106322</u> <u>mf</u> <u>07-12-18</u>			
7.0	MS20426AD33	Rivet	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total: 48.0000 Each(s) Rivet BATCH: <u>m1063</u> <u>mf</u> <u>07-12-18</u>			
8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-C Sink as per Dwg D3637 <u>15- Drill holes per Dwg D3637</u> <u>mf</u> <u>07-12-18</u> 2-Install Nut plate as per Dwg D3637 <u>SAP</u> <u>07-12-18</u> <u>19</u> <u>mf</u> <u>07-12-18</u> <u>19</u>			
9.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP <u>07/12/18</u> <u>15</u>			
10.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: <u>260A</u> <u>07/12/18</u> <u>15</u> ENGINEERING APPROVAL <u>07.12.18</u>			
11.0	QC21	FINAL INSPECTION/W/O RELEASE	
			
Comment: FINAL INSPECTION/W/O RELEASE <u>260A</u> <u>07/12/18</u> <u>15</u>			
Job Completion			
<u>mf</u> <u>2007/12/19</u> <u>152</u> <u>07/12/18</u>			
POSITIVE RECALL EFFECTIVE <u>07-09-11</u> AUTH <u>LL</u> RELEASED <u>LE</u> DATE <u>07-12-18</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

2

1

D

D

C

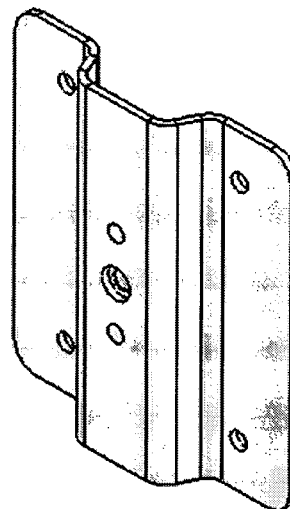
C

B

B

A

A



24

W/634537

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D"
- 7) WEIGHT: 0.27 lbs

PRELIMINARY ISSUE

07-09-07 LE

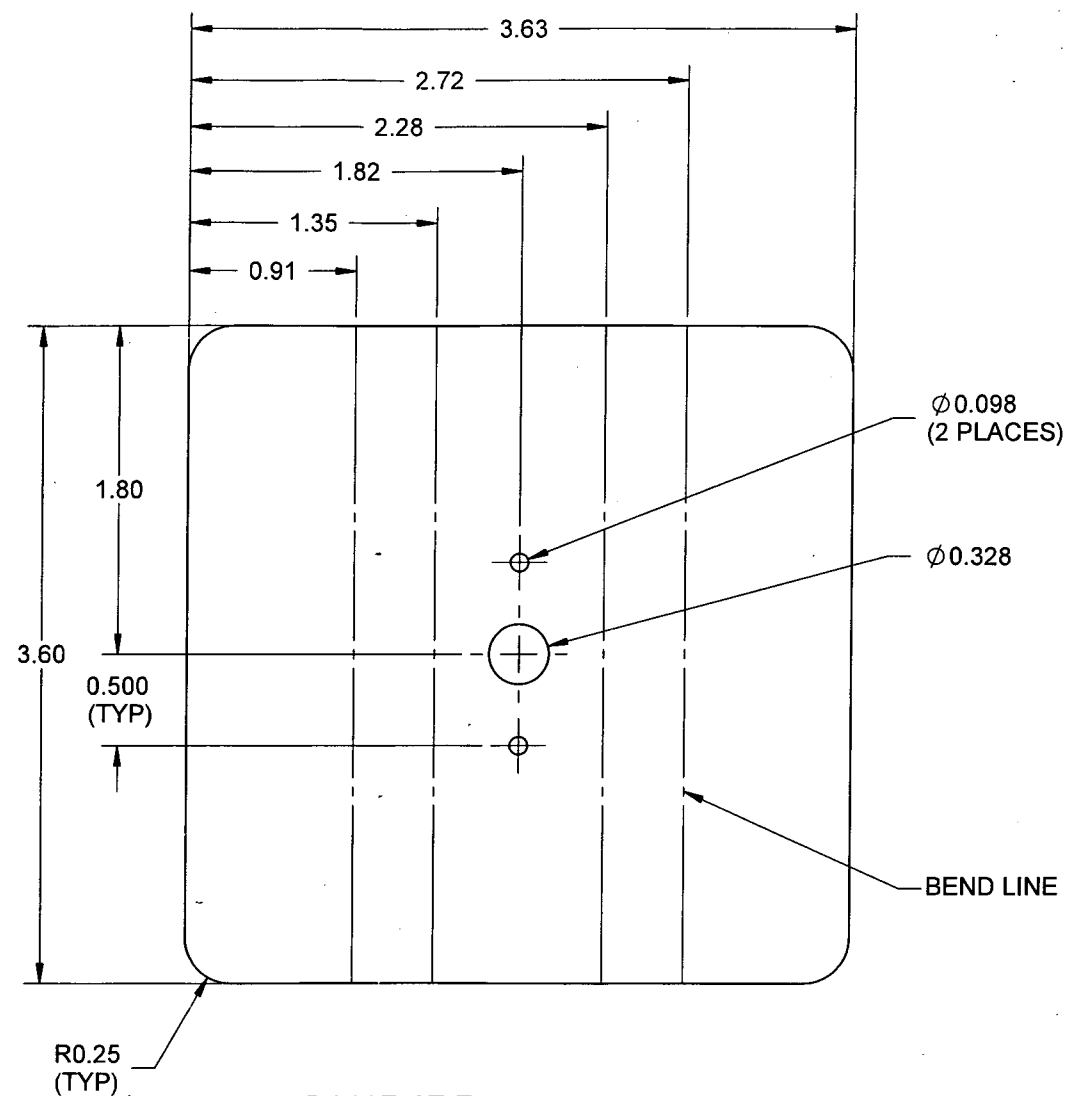
CES G10608, G10602 & G10609		LE	07.07.27
DESCRIPTION		BY	DATE
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3637		REV. A SHEET 1 OF 3	
TITLE BRACKET		SCALE 1:1	
COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

8

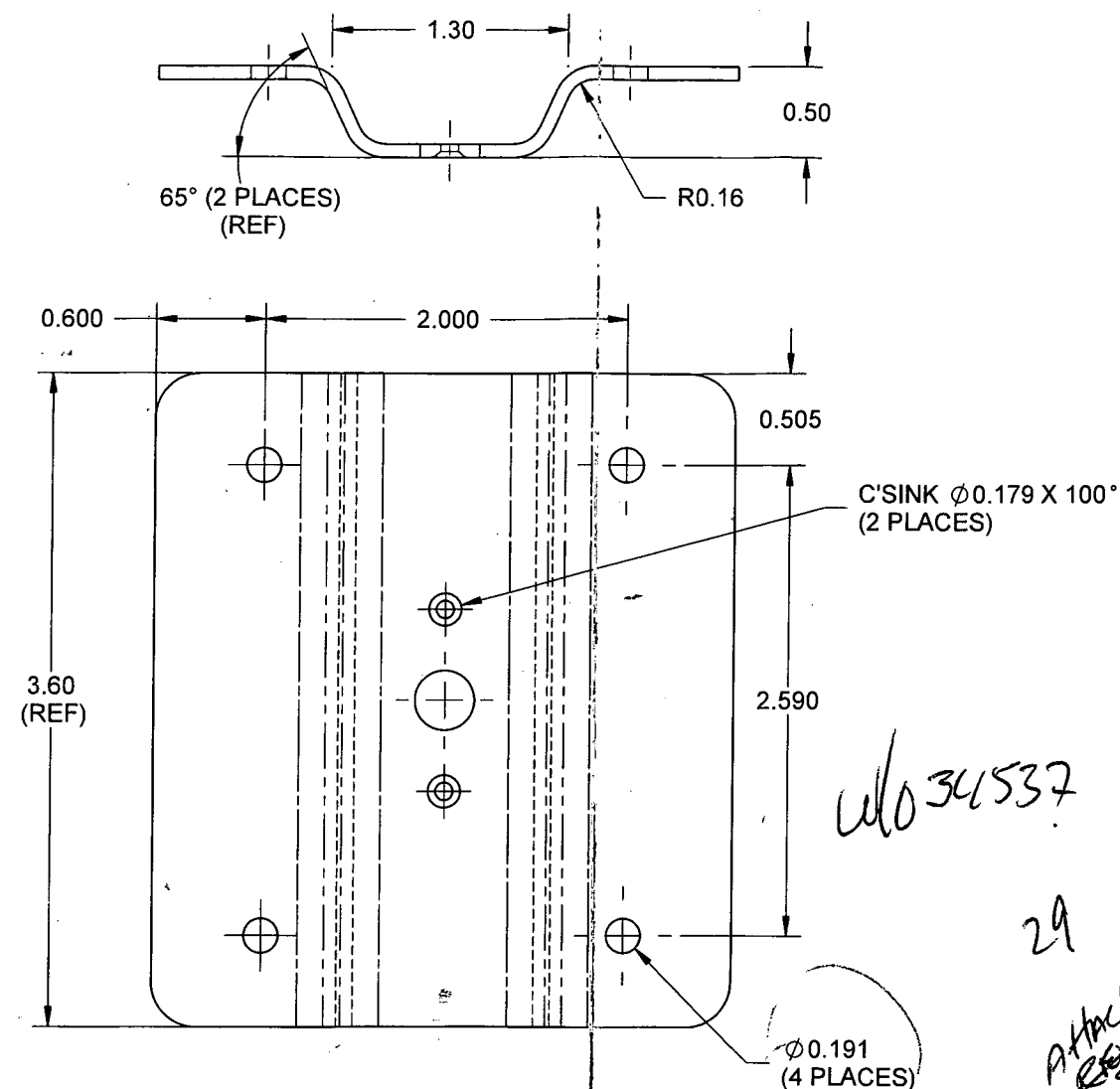
7

2

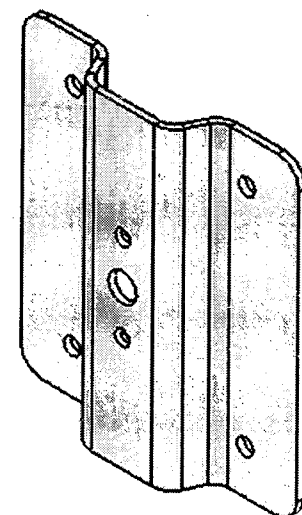
1



D3637-1F FLAT PATTERN



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**



D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

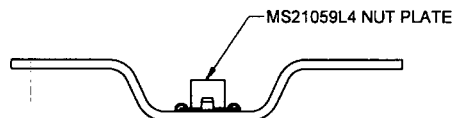
DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	EP	D3637	SHEET 2 OF 3
APPROVED	HP	TITLE	SCALE
DE APPR.		BRACKET	1:1
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PRELIMINARY ISSUE

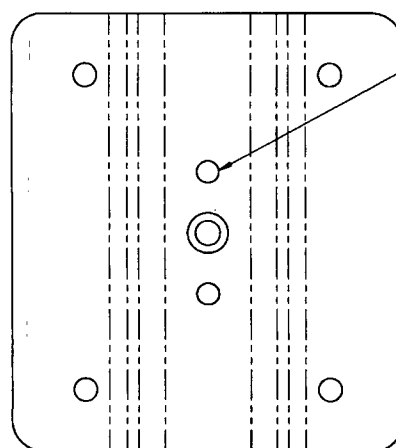
W/O 34537
29
SEE ATTACHED REV A

2.095
2.191
1.8
1.1
1.0

+ 570
0.095
665
1.00

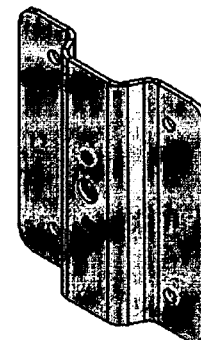


MS21059L4 NUT PLATE



MS20426AD3-3 RIVET
(2 PLACES)

D3637-1 BRACKET



D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

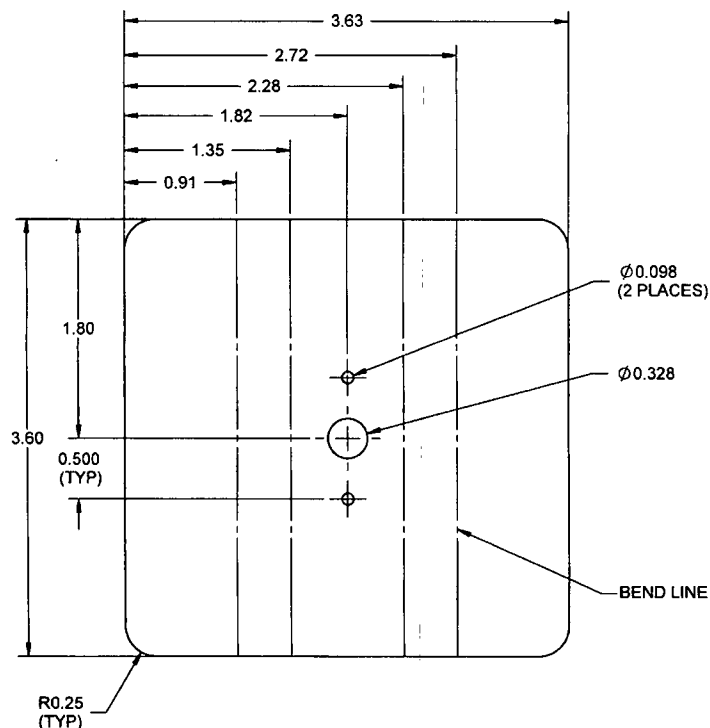
W/O
34537
u

RELEASED
07.09.07

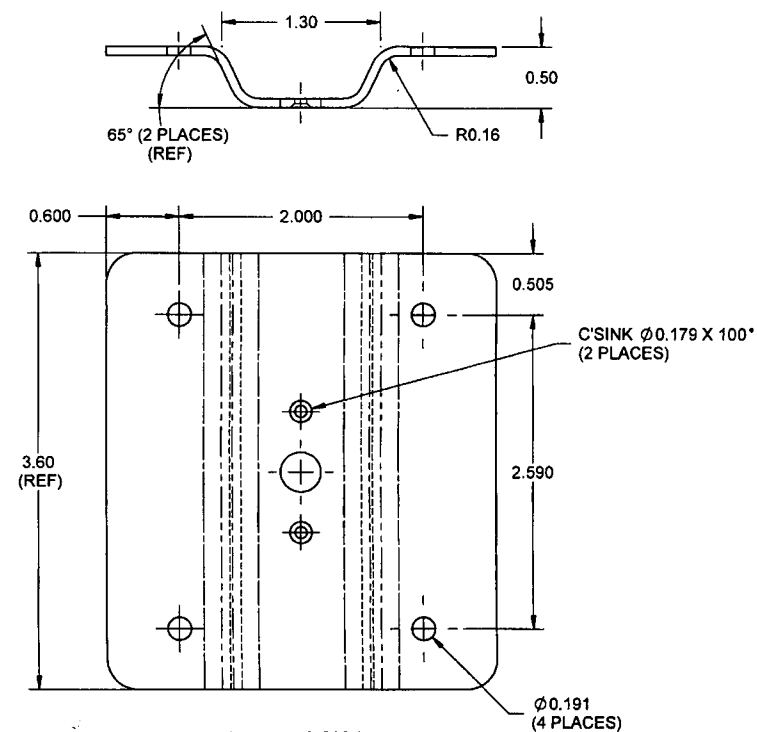
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	JP		
MFG. APPR.	BE		
APPROVED	JP		
DE APPR.	JP		
DATE	07.07.27		

A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
DESIGN	TS		
DRAWN	LE		
CHECKED	JP		
MFG. APPR.	BE		
APPROVED	JP		
DE APPR.	JP		
DATE	07.07.27		

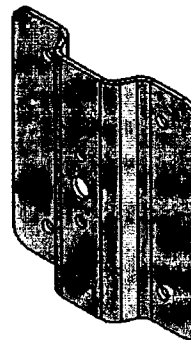
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3637	REV. A SHEET 1 OF 3
TITLE BRACKET	SCALE 1:1
COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3637-1F FLAT PATTERN



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**

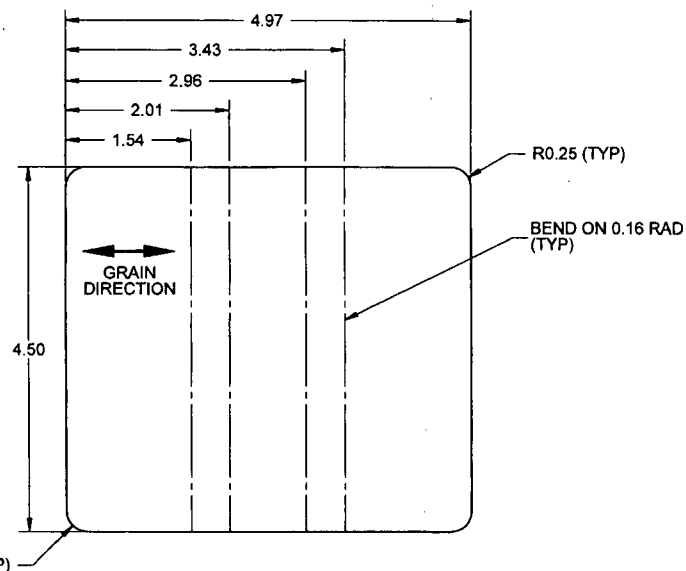


RELEASED
07.09.07

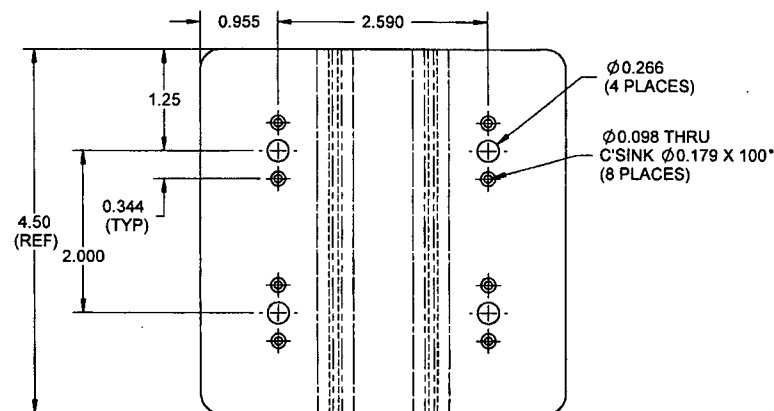
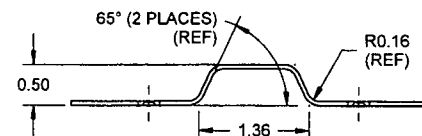
D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

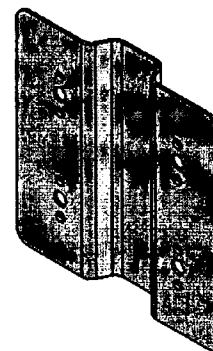
DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D3637	SHEET 2 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BRACKET	1:1
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



RELEASED
07.09.07

D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	CF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CF	DRAWING NO.	REV. A
MFG. APPR.	B	D3637	SHEET 3 OF 3
APPROVED	CF	TITLE	SCALE
DE APPR.	CF	BRACKET	2:3
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			